

CLAIM AMENDMENTS

1 1. (original) A method for controlling the position of
2 a mandrel (10) that is mounted in a hydraulic extrusion apparatus
3 comprising a cylinder and a piston that form a piercing cylinder
4 (8), of an extrusion press for producing pipes (2) that are
5 extruded from billets (4) that are loaded into a holder (5) mounted
6 upstream from the extrusion die (3) and pierced by means of the
7 mandrel (10), characterized in that the piercing cylinder (8) is
8 directly driven by pumps (11) that are adjusted to a defined
9 pumping volume as a function of the extrusion speed and that a
10 further pumping volume is added to the previously computed pump
11 conveying volume, a control valve (16) acting upon the front ring
12 compartment (12) of the piercing cylinder (8) being connected to a
13 sump (17) for the purpose of controlling the position of the
14 mandrel (10).

1 2. (original) The method according to claim 1,
2 characterized in that the outlet pressure of the piercing cylinder
3 (8) is adjusted to a defined pressure.

1 3. (currently amended) The method according to claim 1
2 [[or 2]], characterized in that the pressure levels in both sides
3 of the piercing cylinder (8) are monitored.